Monday, 4/30/2007 7:23:10 AM Kim Johnston **Process Sheet Drawing Name** : SADDLE SPACER : CU-DAR001 Dart Helicopters Services Customer Job Number : 32104 : 10827 **Estimate Number** : D2877 Part Number : N/A P O Number S.O. No. : NA D2877 REV B **Drawing Number** : 4/30/2007 This Issue : N/A Project Number Prsht Rev. **Drawing Revision** : SMALL /MED FAB Type First Issue : 30055 Material **Previous Run** 120 Um: Each Due Date : 5/20/2007 Written By Checked & Approved By 00.05.19 Added inspect level 8 EC : Est Comment Est С 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Updated Thickness as per Rev B 06-09-18 JLM Est Rev:E **Additional Product** Job Number: Description: Seq. #: 6061-T6 .125 Sheet M6061T6S125 1.0 Comment: Qty.: Total: 65.6208 sf(s) 0.5468 sf(s)/Unit Material: 6061-T6 (QQ-A-250/8) 0.125" Thick Batch: M103156 20 WATER JE Comment: FLOW WATER JET 1-Cut as per Dwg D2877 Dwg Rev:\_\_B 01 05 11 2- Tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 QS P019 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

Dart Aerospa	ace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
:										

	\A(C	DK ODDED NON CONEODMA	NCE (NCD)		
			QA: N/C C	losed:	Date:
Part No:	PAR #:	Fault Category:	_ NCR: Yes (No)	DQA:	Date: Oflocias

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Annroval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto		

NOTE: Date & initial all entries

Monday, 4/30/2007 7:23:10 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2877 Job Number: 32104 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57 FINAL INSPECTION/W/O RELEASE QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE W ADG Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			•						
Part No	:	PAR #:	Fault Category:	NCR	: Yes	No <b>DQ</b>	A:	Date: _	
					QA: I	N/C Close	d:	_ Date: _	
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	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification		Annroyal		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B  Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C Section A Section C Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Chief Eng		

NOTE: Date & initial all entries

DART AEROSPACE LTD

Description: Saddle Spacer

Part Number: D2877

Inspection Dwg: D2877 Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.98	+/-0.030	0.987	V		VUN	
R0.06	+/-0.030	RO.06	J		3-6	
R0.30	+/-0.030	RO.30	V		R-G	
1.00	+/-0.030	1.00			yers	
0.250	+0.030/-0.000	0.250	/		VLIN	-
Ø0.257	+0.005/-0.000	0.258			VINN	
<del>-0.100-</del> thick	+/-0.005	0.122	1		Ver	
0.125						
			-			

	•				
Measured by:	N mil	Audited by:		Prototype Approval:	N/A
Date: 0	05 11	Date:	6705.15	Date:	N/A

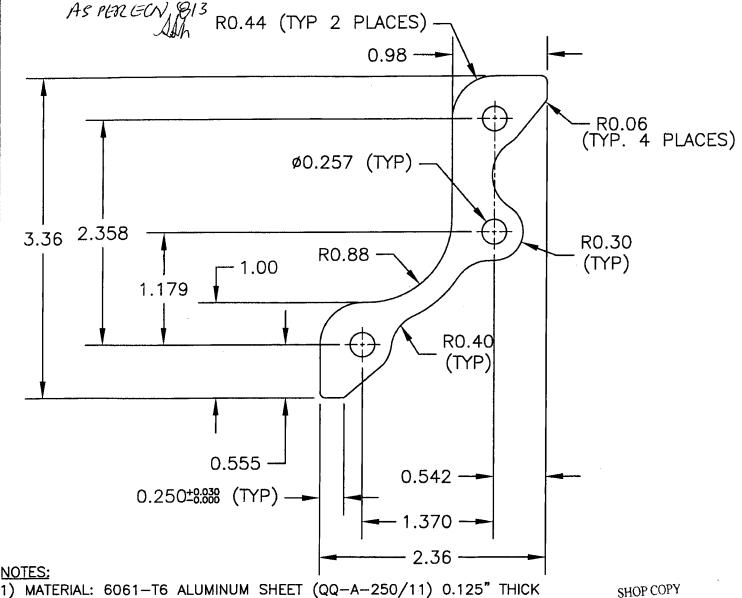
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM o	
	<del>-</del>		, ()	/ /



DESIGN DRAWN BY		DRAWN BY $\subset \mathcal{B}$	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK		APPROVED A	DRAWING NO.	REV. B			
	PH	#	D2877	SHEET 1 OF 1			
DATE			TITLE	SCALE			
06.0	5.17		SADDLE SPACER	1:1			
 Α		99.02.23	NEW ISSUE				

RELEASED

| B | 06.05.17 | THICKNESS WAS 0.100", MAT CHANGE



1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK

(REF\_DART\_SPEC\_M6061T6S.125)

OR

**ENGINEERING** 5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICKUNCONTROLLED COPY SUBJECT TO AMENDMENT (REF DART SPEC M5052H32S.125)

RETURN TO

WITHOUT NOTICE

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

DIMENSIONS ARE IN INCHES

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